

Work Order ID **55960**

February 8, 2010 11:40:54 AM



Page 1

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4055	<del>P</del> <del>A</del>	B rev A

100		0.00
-----	--	------



Purchasing

Memo

0.00

10-2-08

Purchasing

Issue P/O: 11330  
Purchase part as per Dwg D4055  
Possible Supplier: GFI  
Material release note required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

10/3/08 ③

Packaging

Memo

0.00

Packaging

120



QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

*Si 10330g to polem Day only*

Memo

0.00

*change on Day. ~~part~~ parts not in match.*

**QC APPROVAL**

*no insp on ~~refer to~~ Day.*

**PRELIMINARY ISSUE**

*Pto -7*

W/O: 55960		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<del>CHAMFER 2.00" Dims.</del>					

Part No: D4055-7 PAR #: Fault Category: NCR: Yes  No DQA: Date: 10/06/22  
 Resolution: Disposition: QA: N/C Closed: Date:

NCR: 55960		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/08	100	Fwd Q inspection that the .50" <del>is</del> <sup>is</sup> not this part 566-570°. Q G.P.Z. <del>MAS</del>						
		Changes from Part to Rev A Dwg. mark part non conform		Red tag parts.		N/A		
						Rev A is good. to parts. no changes & hold times. parts rev to Rev A Approved.		

NOTE: Date & initial all entries

## Work Order ID 55960



February 8, 2010 11:40:55 AM

Page 2

Item ID: D4055-7 Accept  Setup Start   
 Revision ID:  
 Item Name: Tank Fwd End Stop 

Start Date: 2/08/10 Start Qty: 3.00   
 Required Date: 2/22/10 Req'd Qty: 3.00 

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start 
	QC:	Date:	SPC (Y/N):	Date:	Stop 	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005.41  Memo	0.00							
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00							

Identify as per dwg & Stock Location: <u>Preel</u> 0.00	<u>Shelf</u> 0.00	<u>JUL 10.03.13</u>	(3)
---------------------------------------------------------	-------------------	---------------------	-----

<u>WA</u>	<u>Lat Liver</u>	(2) 10.06.28
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**Work Order ID 55960**

Page 3

February 8, 2010 11:40:55 AM

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Item Name: Tank Fwd End

Stop



Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/28 HJ

BS 10-4-14 (3)

## POSITIVE RECALL

EFFECTIVE 10/06/28 AUTH URELEASED J DATE 10/06/28 QTY 2

## Picklist Print

February 8, 2010 11:40:54 AM

Page 1

**Work Order ID:** 55960



**Parent Item:** D4055-7



**Parent Item Name:** Tank Fwd End

**Comments:** IPP RevA: new issue DD 10.01.08 verified by:JLM

**Start Date:** 2/08/10

**Required Date:** 2/22/10

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Oty on	Remaining	Qty	Date
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-----------	-----	------

Start Qty: 3.00

**Required Qty:** 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-7P 		Purchased	No			110	Each	0.0000	3.0000 		10/3/4 (3)	



GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

**180 AVENUE LABROSSE  
POINT-CLAIRE, QC, CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849**



**BON DE LIVRAISON / SHIPPING MEMO**

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO. - MO.	AN. - YR		
02	03	10	0433554	1/1

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION	
3	D4055-7P	TANK FWD END	CERTIFICATE OF CONFORMANCE REQ
	MFG. JOB# <u>J0210446-001</u> QTY <u>3</u>	(1) Box	
			

**REÇU PAR / RECEIVED BY**

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

# **CERTIFICATE OF COMPLIANCE**

## **CERTIFICAT DE CONFORMITE**

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0210446 SHIPPING MEMO 0433554

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	3 PCS	PO11330	D4055-7P		TANK FWD END	PA1

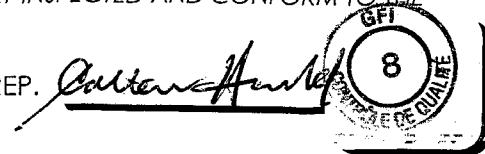
**MATERIAL** **SUPPLIED BY** **MAT. REL. NO.**  
**AL 6061-T6** **SAMUEL / ALCOA INC** **608951**

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2	REF. GFI MANUFACTURING JOB NUMBER J0210446-001 (3 PCS)		
3			
4			
5			
6			
7			
8			
9			

-WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED  
ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE  
DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE

DATE - 03 MARCH 2010

G.F.I. Q.C., REP.



**SAMUEL**

LES METAUX SPECIALISES SAMUEL  
 21525 CLARK-GRAHAM  
 BAIE D'URFE, QUEBEC, CANADA  
 H9X 3T5

No 001591859



(514) 457-3399 FAX(514) 457-9393

PAGE 1 DE/OF 1

ANSPORTEUR/CARRIER NAME  
 ASTERO TRANSPORT

CAMIONTRUCK NOM DE LA BRANCHE/SALES BRANCH NAME  
 099 SAMUEL & FILS & CIE (QUEBEC) L

DATE D'EXPÉDITION/SHIPMENT DATE 2/16/10

**VENDU À/SOLD TO:**

GFI, DIVISION DE THOMAS & BETTS LTEE  
 180 LABROSSE

**EXPÉDIÉ À/SHIP TO:** TAB: PPD  
 GFI INC.  
 180 LABROSSE

POINTE-CLAIRES  
 QC  
 H9R1A1

(514) 630-4877

POINTE-CLAIRES  
 QC  
 H9R1A1 CA

(201009-00001)

N° COMMANDE N° ITEM	DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT				
000752-01	#Comm du client: 76423				
	4 PCS AL. SH. 6061 T6				
	.0630"x48"x144"				
	QQA 250/11				
	#Pièce AS06348144QM				
	Description	Art	Pd ca	Qté	
	#Étiq mln	#À soul			#Étiq
					Étq princ
	764479	4	192.000	174	#Coul
	Total:	4	192.000	174	4947487 ALR US
					D654824 608951

Poids total:

#Total paquets:

174 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ  
 LE MATERIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ  
 CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX  
 SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS  
 RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

*M. Diamond*  
 MELISSA DIAMOND  
 ADMINISTRATION

DATE 16/02/10

INSPECTION  
72  
SAMUEL

NIR: R-539477-1

PAR CHARGES	PORT PAYÉ/PREPAY PORT D'COLLECT	INST. VOITURIER/DRIVER INSTRUCTIONS	VALISE (52.000\$ max. moins d'avis connaisse)
EXPEDITEUR/DISPATCHER		VOITURIER/DRIVER	VALISE DECLARÉE DE L'EXPEDITEUR DECLARÉE A L'ALICE CHAMBERLAIN
			REÇU PAR/RECEIVED BY

1. ORIGINAL - NON NÉGOCIABLE (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.  
Per:

*Malcolm Murphy*  
Malcolm Murphy  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

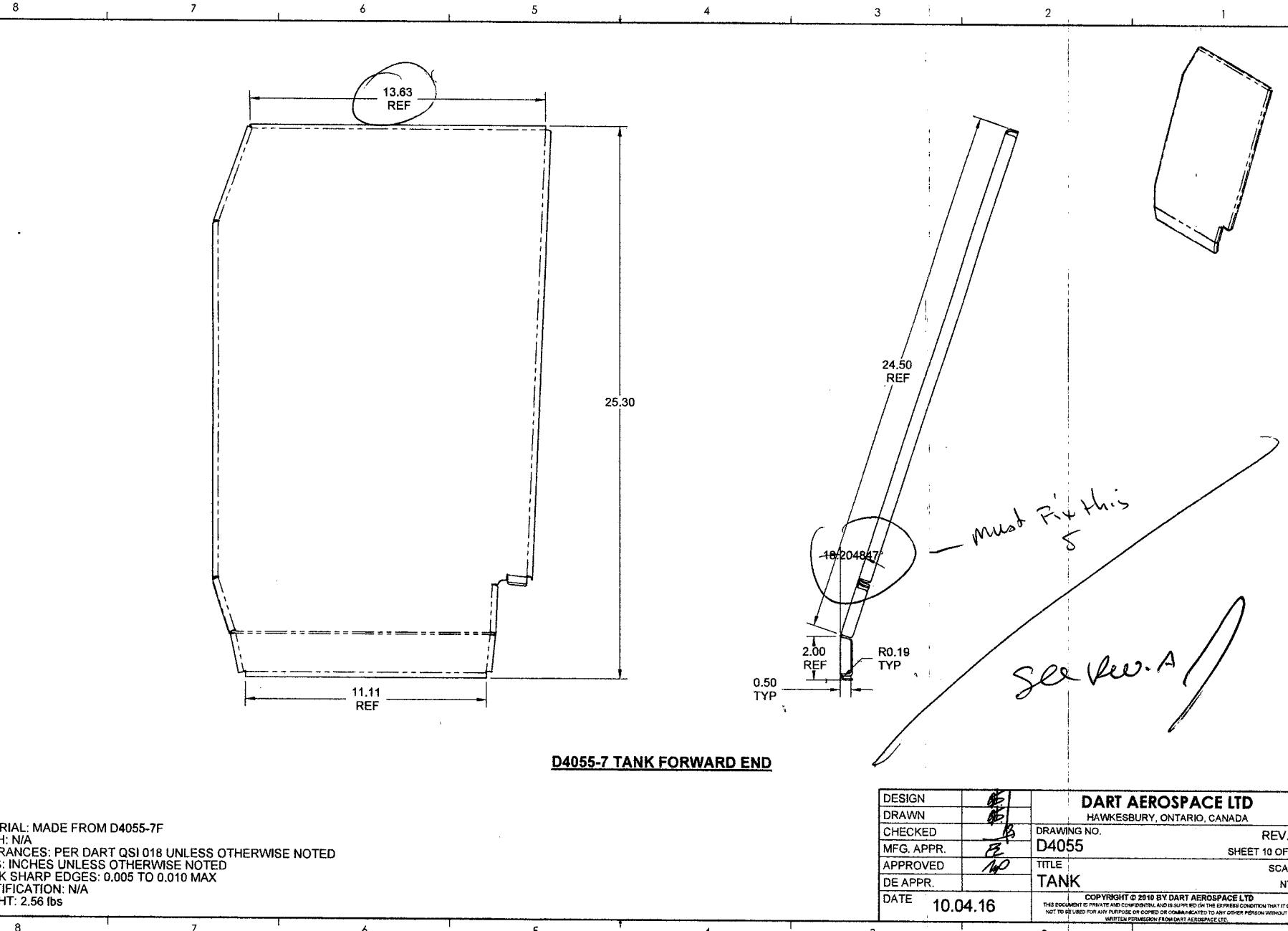
1058276 Ship Date	0 B.L. No.	Invoice No. Alcoa No. Item	Page 2 DCE-43904-6
2009-10-15 P.O. No./Govt Contract No.	4303234 Customer	00000 1000143904-6 N22238 Ln#: 6 SAMUEL SON & CO LT 0041110647R02	Alcoa Item

CQR: 0222751.2 -Specification Limits (cont.)  
Lot: 608951 - Mechanical, Physical, Metallography, Quantometer Results

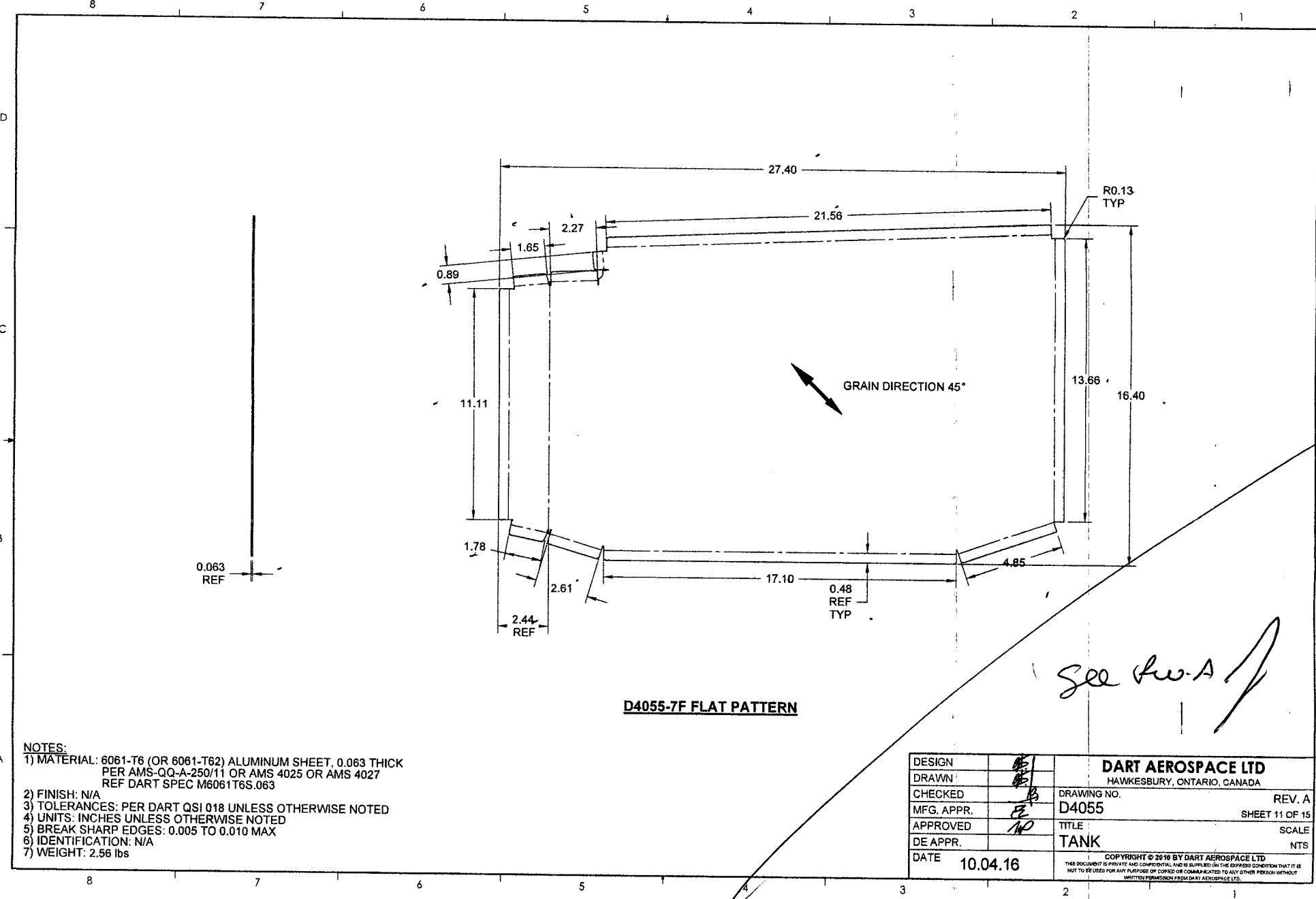
Tmpr	Dir	No->	UTS	TYs	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	50	44.8	10.9
			49.9	44.8	10.9

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H8054013	Actuals	0.66	0.5	0.26	0.06	0.9	0.19	0.05	0.02

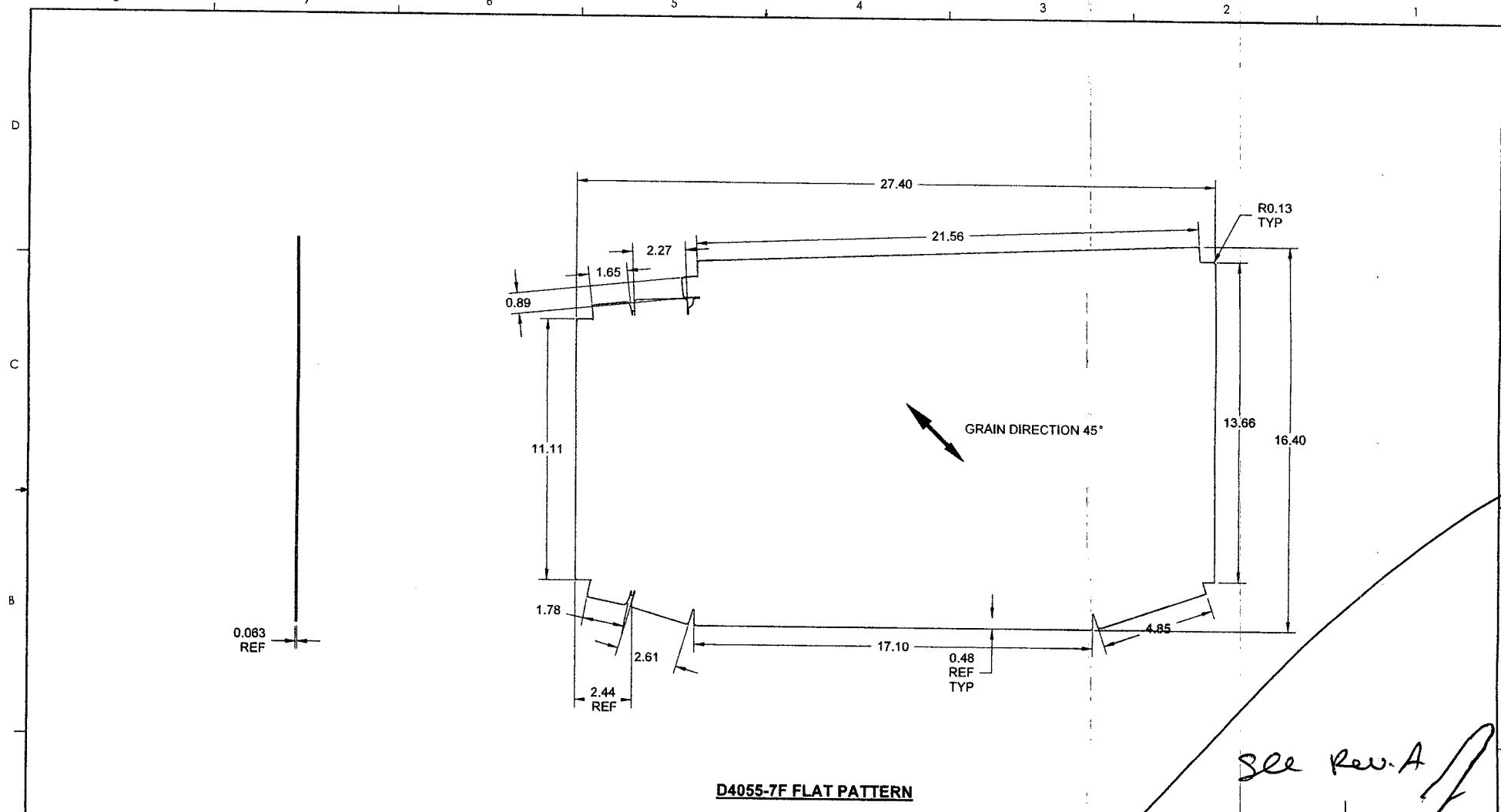
This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	
MFG. APPR.		REV. A	
APPROVED		SHEET 10 OF 15	
DE APPR.		TITLE	SCALE
		TANK	NTS
DATE 10.04.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1



**PRELIMINARY ISSUE**

10.03.31

**NOTES:**

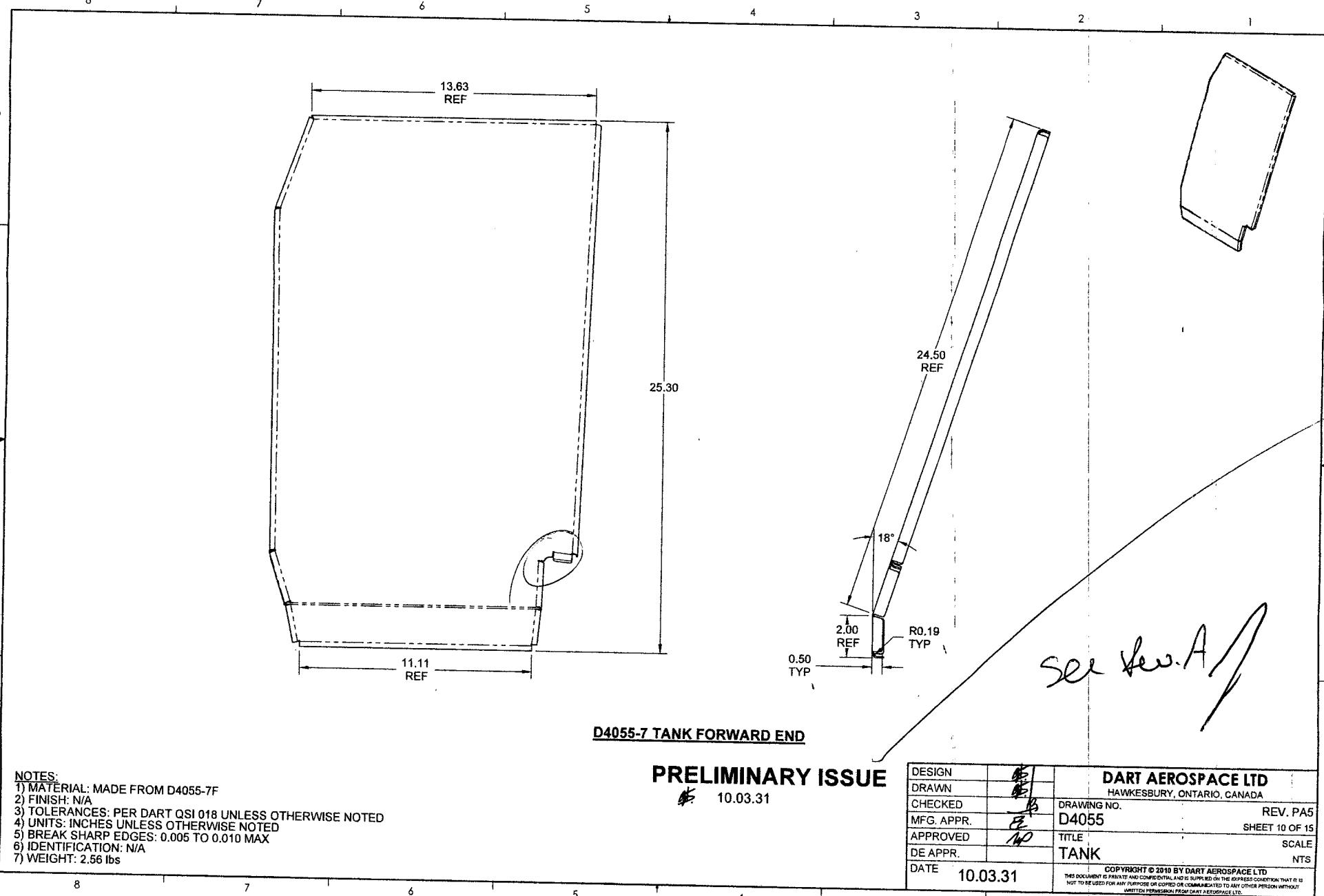
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

8 7 6 5 4 3 2 1

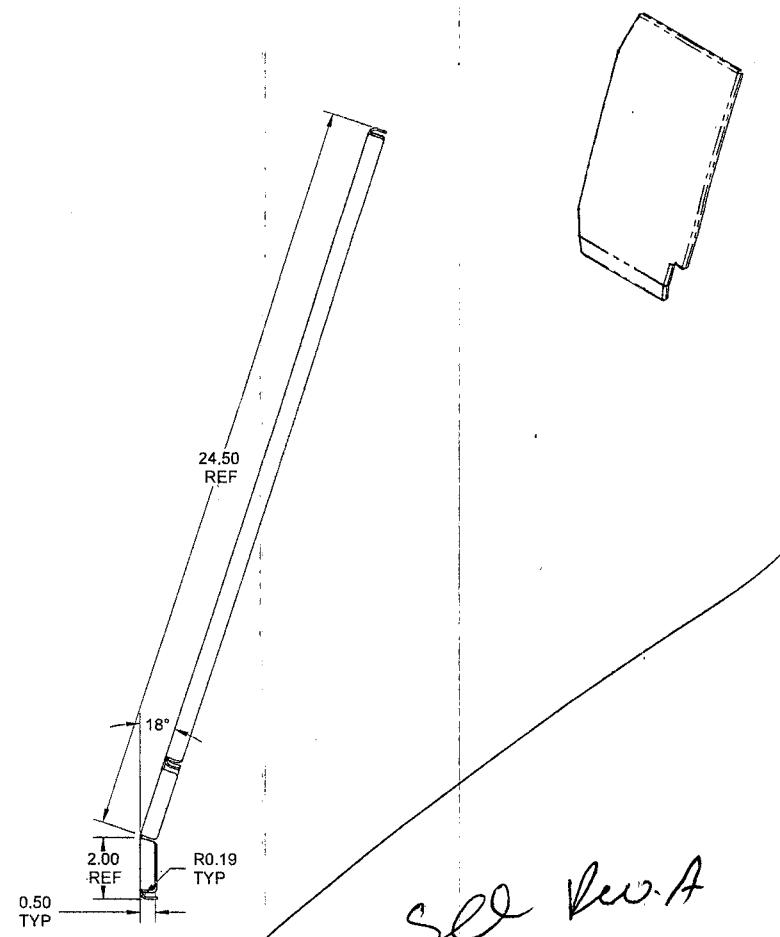
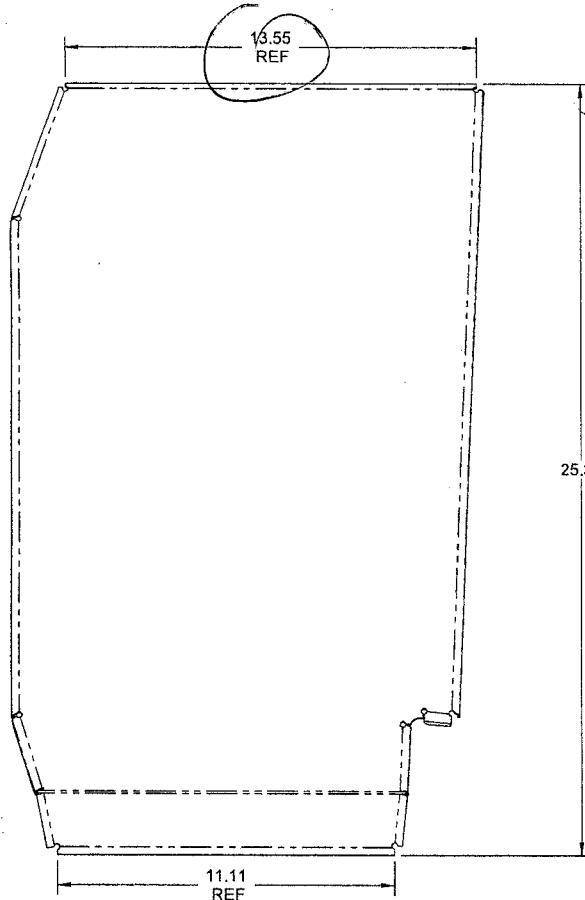
DESIGN	<i>E1</i>	DART AEROSPACE LTD	
DRAWN	<i>E1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>P3</i>	DRAWING NO.	
MFG. APPR.	<i>E2</i>	D4055	REV. PA5
APPROVED	<i>ADP</i>	SHEET 11 OF 15	
DE APPR.		TITLE	SCALE
DATE	10.03.31	TANK	NTS

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*See Rev. A*



**NOTES:**  
 1) MATERIAL: MADE FROM D4055-7F  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 2.56 lbs



D4055-7 TANK FORWARD END

PRELIMINARY ISSUE

10.01.11

- NOTES:
- 1) MATERIAL: MADE FROM D4055-7F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.56 lbs

DESIGN DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.01.11

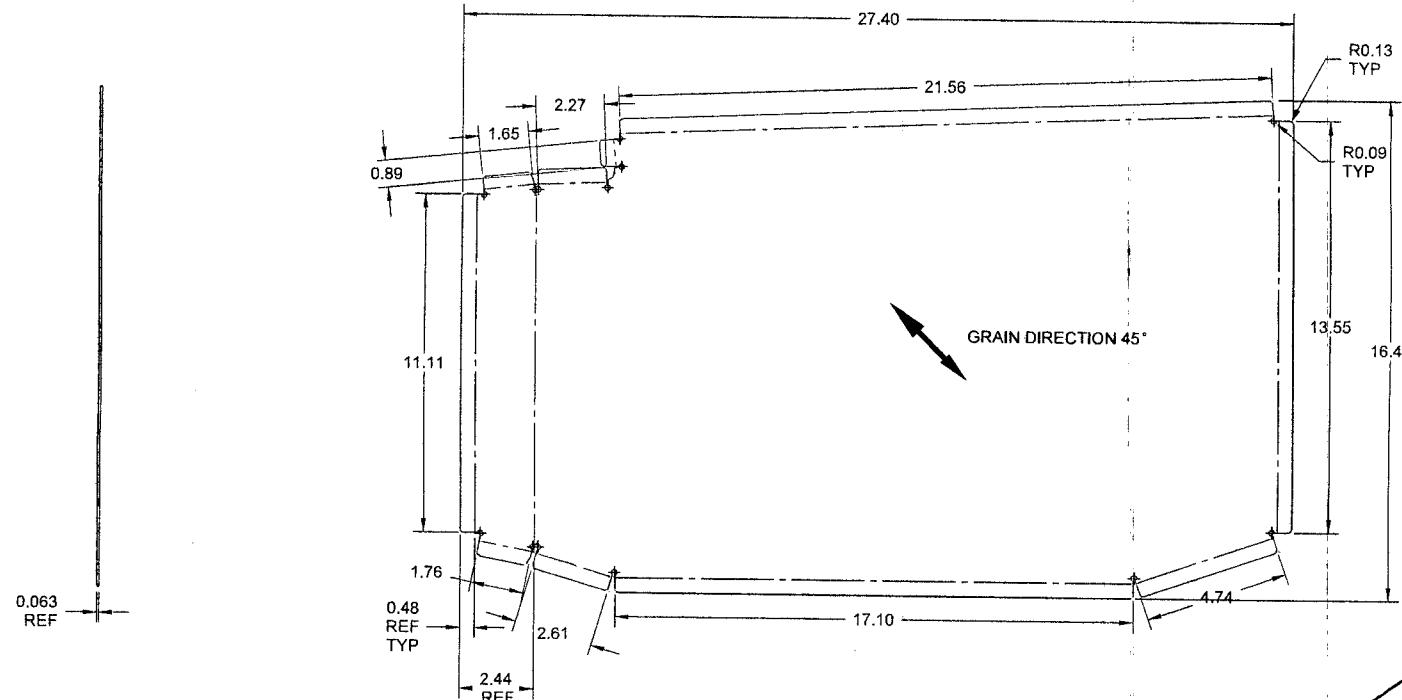
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D4055** REV. PA1  
SHEET 10 OF 15

SCALE  
NTS

TITLE  
**TANK**

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D4055-7F FLAT PATTERN

**PRELIMINARY ISSUE**

# 10.01.11

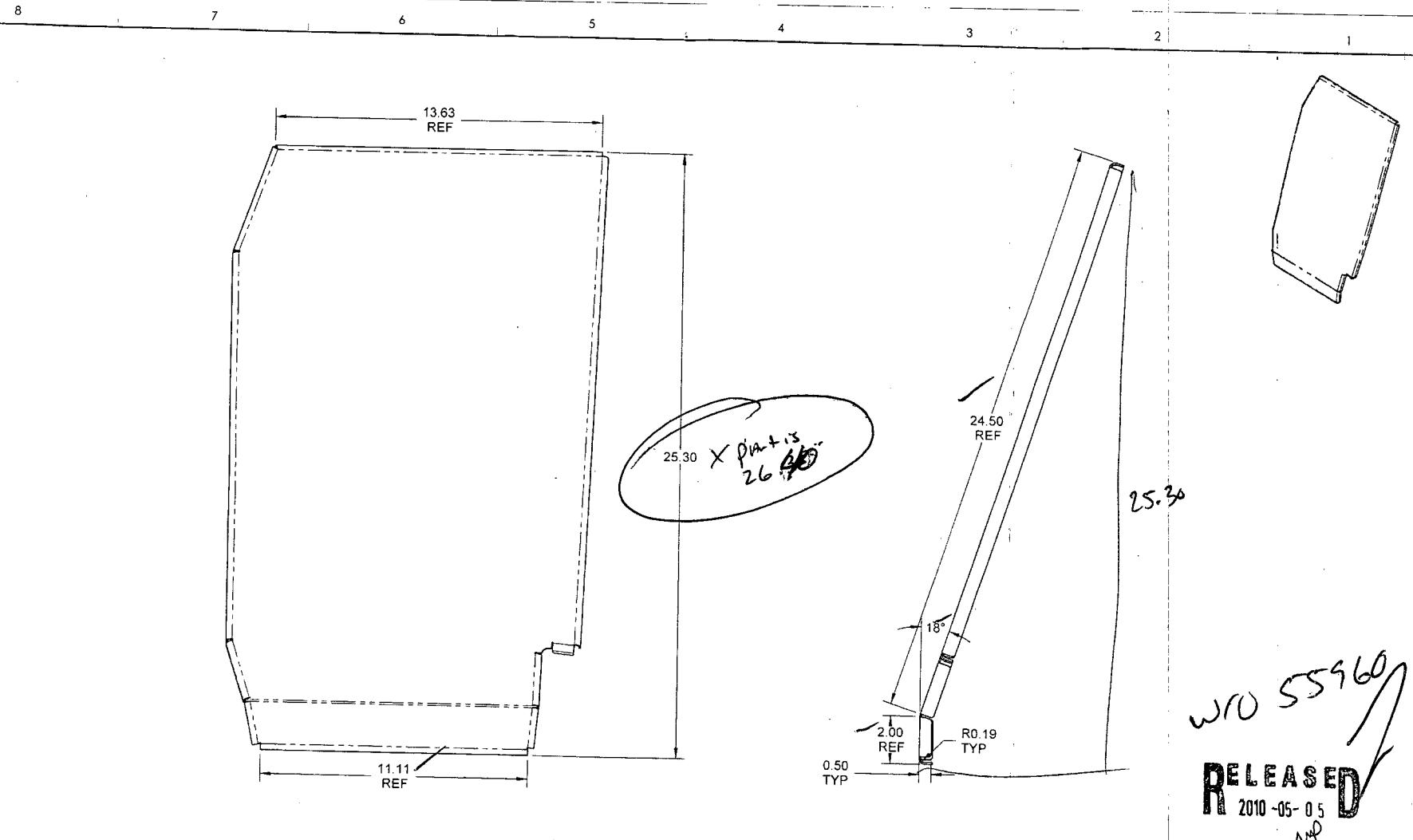
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN	DRAWN	checked	DART AEROSPACE LTD	
CHECKED	MFG. APPR.	APPROVED	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	APPROVED	DE APPR.	DRAWING NO.	REV. PA1
APPROVED	DE APPR.	DATE	D4055	SHEET 11 OF 15
DE APPR.	DATE	10.01.11	TITLE	SCALE
			TANK	NTS

*See Rev. A*

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D4055-7 TANK FORWARD END

- NOTES:  
 1) MATERIAL: MADE FROM D4055-7F  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 2.56 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. A
MFG. APPR.	<i>[Signature]</i>	DRAWING NO.
APPROVED	<i>[Signature]</i>	D4055
DE APPR.	<i>[Signature]</i>	SHEET 10 OF 15
DATE	10.04.16	TITLE
		SCALE
		NTS

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**RELEASED**  
 2010-05-05  
*WFO 55960*

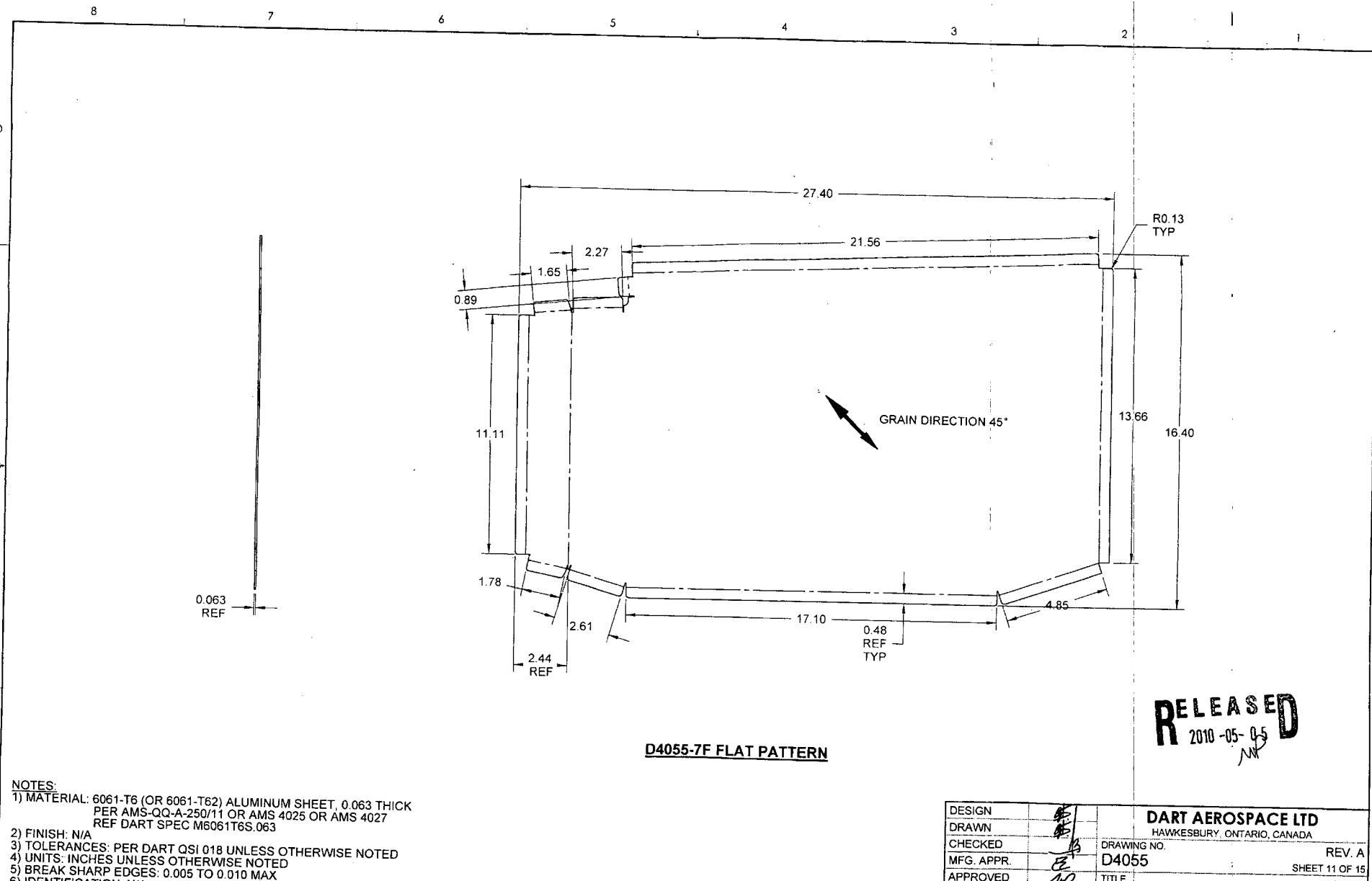
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		REV. A
APPROVED		SHEET 11 OF 15
DE APPR.		TITLE
DATE	10.04.16	SCALE
		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries